

Date: Wednesday, 20/05/2009 10:09:18 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARPAW INSTALLATION
Job Number :	48076		
Estimate Number :	13622		
P.O. Number :		Part Number :	D600572015
This Issue :	20/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN D600-572 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	42790	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>MF 09-05-20</u>	Due Date :	27/05/2009
Comment :	Est Rev:B Reformat,incorporated D2996 KJ/RF 03-06-02		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: H for JLD 09/05/20
 Comment: Photocopy bluefile & type labels per PPP D600-572-015

CHG 002



2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING
 Program Batch Number



3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 5.6839 sf(s)/Unit Total : 17.0516 sf(s)
 UHMW 1" Black
 Batch: _____



4.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 CUT BLANK AS PER FILE D2996_BLANK



5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1



1-Inspect for surface damage

2- Mill as per Folio FA120 Rev: _____ & Dwg D2996 Rev: _____

3-Deburr per dwg D2996

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/05/2009 10:09:18 AM
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Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK

5 (B)



mf 09-05-20

D2996 x 204

Total: 6



Comment: SECOND CHECK

B 47761

SS 09/05/20

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.1053 f(s)/Unit Total: 6.3158 f(s)

Rubber Cushion 6" long x4

batch:

B45405

SS 09/05/20 (X3)

10.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Radius Block

BATCH:

B47796

SS 09/05/20 (X3)

11.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Clamp

BATCH:

B42407

SS 09/05/20 (X3)

12.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

BATCH:

B45388

SS 09/05/20 (X3)

13.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bolt

BATCH:

M111477

SS 09/05/20 (X3)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: BEARPAW INSTALLATION

Job Number: 48076

Part Number: D600572015

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

BATCH: M111279

15.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

BATCH: M110450

16.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Clamp

BATCH: M111383

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D600572-015

Location:

PPP Rev:

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-20

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

#48076

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

32.4 PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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